

*Push Ship Today*

Work Order ID 106586-2

\*106586\*

*WSTH* Page 1

Item ID: D3866-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Plate

Start Date: 9/9/2013

Start Qty: ~~4.00~~ *7*

\*4\*

Cust Item ID:

Required Date: 9/9/2013

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *13-9-9*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

3866

A

100

FLOW WATER JET

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3866

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

34

0

*Ak*  
13.09.09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

34

0

*Ak*  
13.09.09

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

*27*  
*Baq*

*34*  
*Alan*



**Work Order ID 106586**

Monday, September 09, 2013 10:22:01 AM

**\*106586\***

Page 2

Item ID: D3866-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Plate

Stop **\*NS2\***

Start Date: 9/9/2013 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 9/9/2013 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

Small Fab

Memo

1- deburr

2- form as per dwg D3866

0.00

0.00

7

SB  
13/09/10

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS  
27  
1390

7

150

**\*150\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

7 13-9-10

51



# Work Order ID 106586

Monday, September 09, 2013 10:22:01 AM

**\*106586\***

Page 3

Item ID: D3866-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Plate  
 Start Date: 9/9/2013 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 9/9/2013 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC3 Inspect Part Finish  Memo	0.00 0.00 13 9 10				7			
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>ST068(5x)</u>  Memo 2x GA	0.00 0.00				7x			
180 <b>*180*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

13/9/11/14

33

11

# Picklist Print

Monday, September 09, 2013 10:21:59 AM

Page 1

Work Order ID: 106586

Parent Item: D3866-3

Parent Item Name: Plate

Start Date: 9/9/2013

Required Date: 9/9/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 09-01-19 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	143.4062	0.1	0.4			

Ac 13.09.09

Location	Loc Qty	Loc Code
MAT021	143.4061578	
121473	0.9161578	
123279	72.89	
125257	10	
M126075	27.6	
M126610	32	

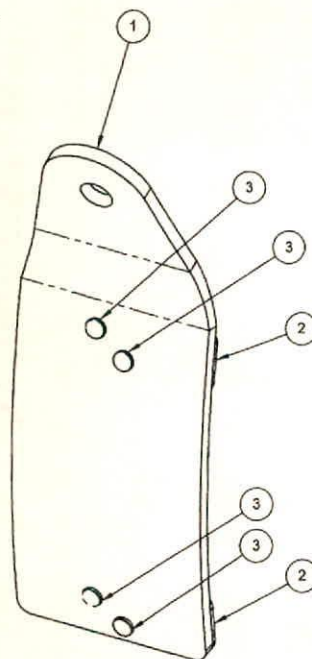
13/02/09  
Revised  
map.

125257 → 3.4





ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3866-1	MOUNT	1
2	D3868-1	SPACER	2
3	MS20428AD3-8	RIVET	4



**D3866-041 MOUNT**

**RELEASED**  
07/12/13

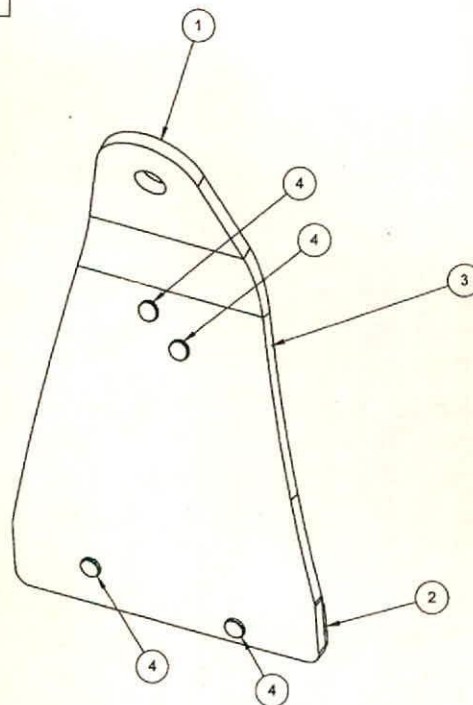
NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3866-041" & B/N USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.10 lbs

A	NEW ISSUE	09.01.13
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.01.13	

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3866</b>	REV. A
TITLE <b>MOUNT</b>	SCALE NTS
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3866-3	MOUNT	1
2	D3866-3	SPACER	1
3	D3866-5	SPACER	1
4	MS20426AD3-8	RIVET	4



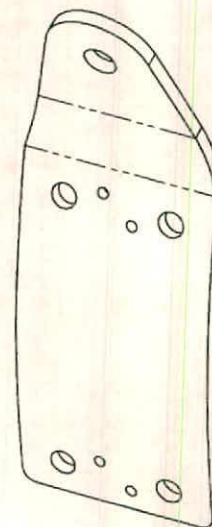
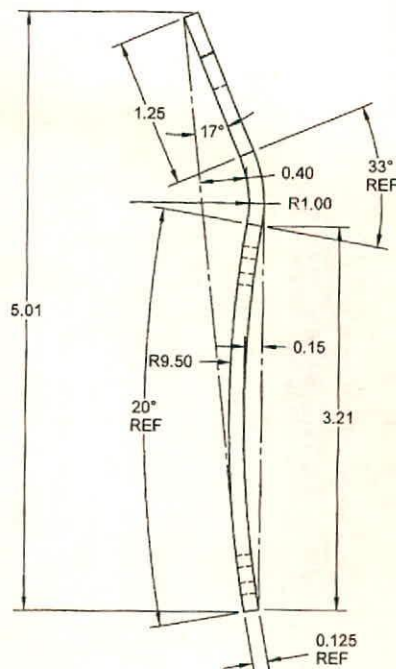
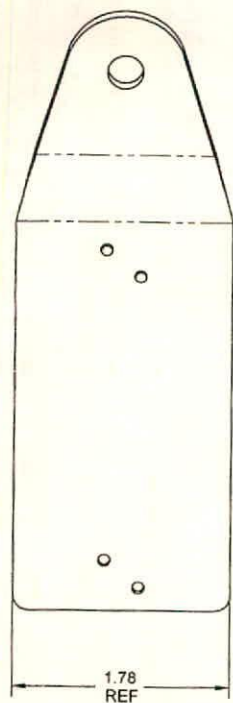
**D3866-043 MOUNT**

**RELEASED**  
09/01/13

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3866-043" & B/N USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.13 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3866	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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**D3866-1 PLATE**  
MADE FROM D3866-1F

106586

**RELEASED**  
2/16/13

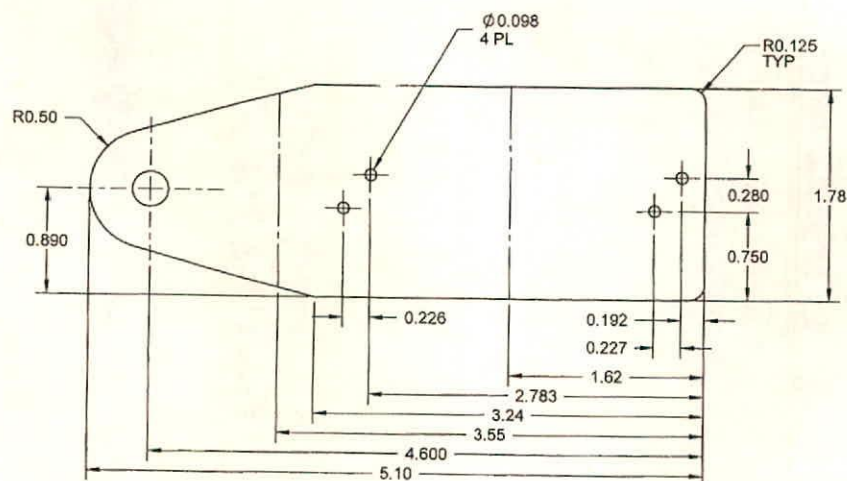
**NOTES:**

- 1) MATERIAL: MADE FROM D3866-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	<del>1</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>1</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>1</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>1</del>	D3866	SHEET 3 OF 6
APPROVED	<del>1</del>	TITLE	SCALE
DE APPR.	<del>1</del>	MOUNT	NTS
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**D3866-1F PLATE FLAT PATTERN**

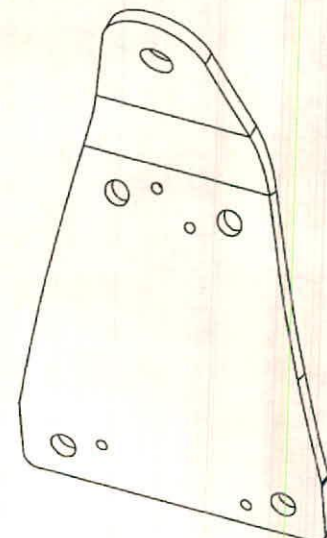
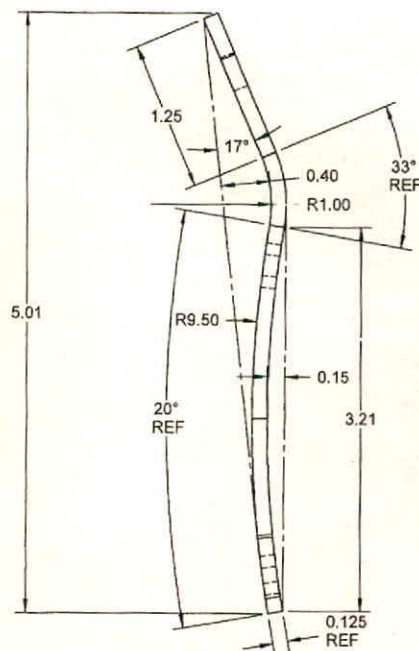
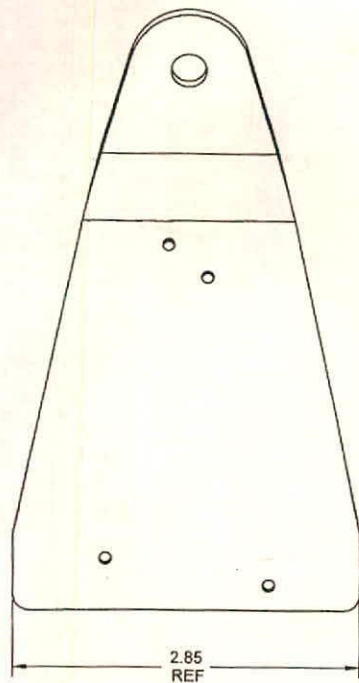
**RELEASED**  
9/16/13 MP

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3866	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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**D3866-3 PLATE**  
MADE FROM D3866-3F

106586

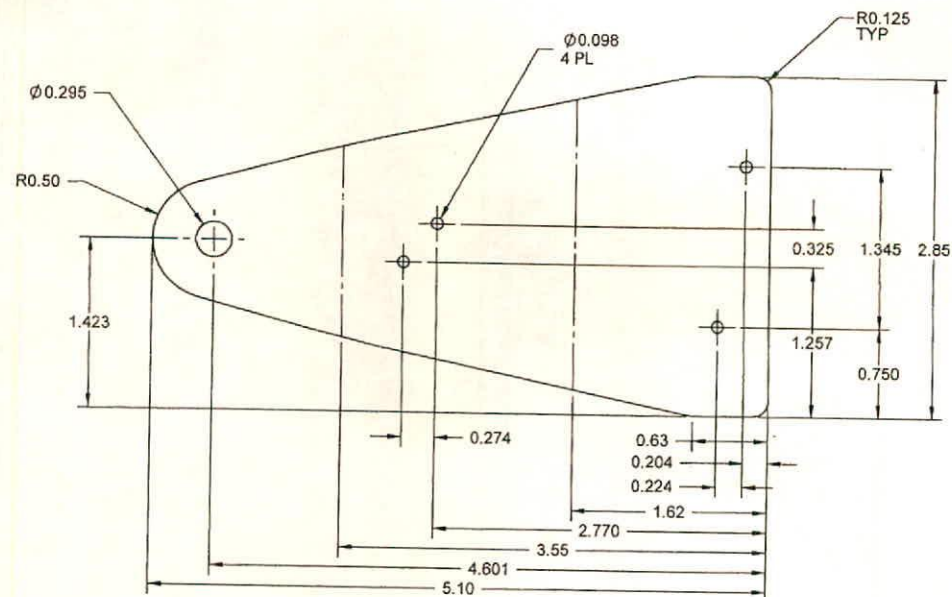
**RELEASED**  
09/21/28

- NOTES:**
- 1) MATERIAL: MADE FROM D3866-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.12 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3866	SHEET 5 OF 6
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**D3866-3F PLATE FLAT PATTERN**

**RELEASED**  
07/01/13 MP

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3866	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 106586
<b>Description:</b> PLATE		<b>Part Number:</b> 3866-3
<b>Inspection Dwg:</b> 3866	<b>Rev:</b> A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	-		✓	Jkm-01
Ø .295	+ .006 - .001	.298	-		✓	
1.423	+/- .010	1.423	-		✓	
1.345	+/- .010	1.345	-		✓	
1.257	+/- .010	1.257	-		✓	
2.85	+/- .030	2.84	-		✓	
.750	+/- .010	.750	-		✓	
.325	+/- .010	.325	-		✓	
.63	+/- .030	.63	-		✓	
.204	+/- .010	.204	-		✓	
.224	+/- .010	.224	-		✓	
1.62	+/- .030	1.62	-		✓	
.274	+/- .010	.274	-		✓	
2.770	+/- .030	2.770	-		✓	
3.55	+/- .030	3.55	-		✓	
4.601	+/- .010	4.601	-		✓	
5.10	+/- .030	5.10	-		✓	
.125	+/- .010	.120	-		✓	

<b>Measured by:</b> <i>AK</i>	<b>Audited by:</b> <i>AK</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 13.09.09	<b>Date:</b> 13.09.09	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*

